



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA25A-110
Job Sheet 172850



Part No: SWA25A-110

Job Qty: 3 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG SWA25A-110 REV:6 IPP REV A 18.02.20 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	3/29/18	3/29/18	0.00	0.00	Start Up Machining-3		
110	Mori Seiki	3 pcs	3/29/18	3/29/18	0.00	3.00	MORI NLX		
120	QC	3 pcs	3/29/18	3/29/18	0.00	0.00	QC2		
122	CNC Vertical Machining	3 pcs	3/30/18	3/30/18	0.00	3.00	HAAS 1		
124	QC	3 pcs	3/30/18	3/30/18	0.00	0.00	QC2 Machining-3		
130	QC	3 pcs	3/30/18	3/30/18	0.00	0.00	QC8		
140	Packaging	3 pcs	3/30/18	3/30/18	0.00	0.00	Packaging3		
150	QC21-SA	3 Ea	3/30/18	3/30/18	0.00	0.00	QC21		

Part Op 110 - Cut Blanks AT 7.00" 1-Machine as per DWG. FB 900 FOLIO REV: DWG REV:
Descriptions: 2-Deburr ***Machine engrave B/N*** 3- PLEASE SEE PER TO CHANGE ENGRAVING
122 - 1-Machine as per DWG. FB FOLIO REV: DWG REV: 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R3.000	17-4 H1150 Round Bar 3.000"	1.7490 ft (.583 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-H1150-R3.000	18	18	0

Part Specifications

Specifications could not be found.



Container No: S047070



Part: SWA25A-110

Job No: 172850

Serial No/Batch: S047070

Revision: 6

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 2/22/18 8:16 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD		Work Order:	172856
Description: Lower End		Part Number:	102-5850
Inspection Dwg: SWA25A-110		Rev: 6	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.530	+0.015 / -0.000	1.534			mic	mic LPO5
1.350	±0.005	1.352			H.G.	
.03x45°	+/-0.010 x.5°	.03x45°			Vern	LPO9
2.69	±0.01	2.690			H.G.	
1.735	±0.005	1.735			Vern	LPO9
1.963	±0.001	1.9625			mic	LPO2
.395	±0.005	.395			Vern	LPO9
2.3155	±0.0025	2.315			H.G.	
Ø2.70	±0.01	2.700			Vern	LPO9
2.125	±0.005	2.125			↓	
.366	±0.005	.365			H.G.	
.030	±0.005	.029			Vern	LPO9
R.25	±0.01	.250			R.G.	
.820	±0.005	.820			H.G.	
R.25	±0.010	.250			R.G.	
.04x45°	±0.01 x.5°	.03x45°			Vern	LPO9
10-32UNF-2B	G0-M06-0	G0			↓	
.25	±0.01	.245			↓	
Ø.500	±0.005	.501			↓	
1.35	±0.01	1.35			↓	
.200	±0.005	.199			↓	
3.10	±0.01	3.100			H.G.	
3.25	±0.01	3.250			↓	
3.70	±0.01	3.700			↓	
6.87	±0.01	6.875			↓	
R.13	±0.01	.125			Rad.G.	
.04x45°	±0.01 x.5°	.04x45°			Vern	LPO9
R.03	±0.01	.032			↓	
.03x45°	±0.01 x.5°	.03x45°			↓	

Measured by:	<i>[Signature]</i>	Checked by:		QC Inspector:	
Date:	18-03-09	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



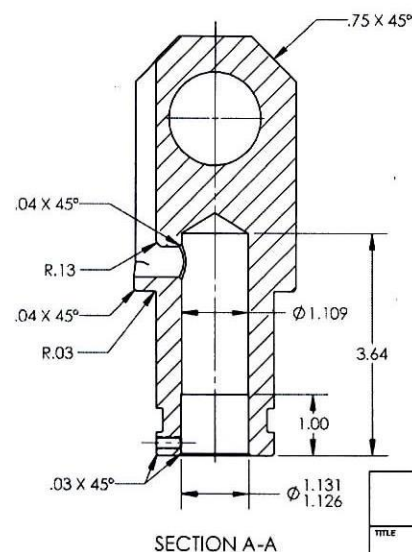
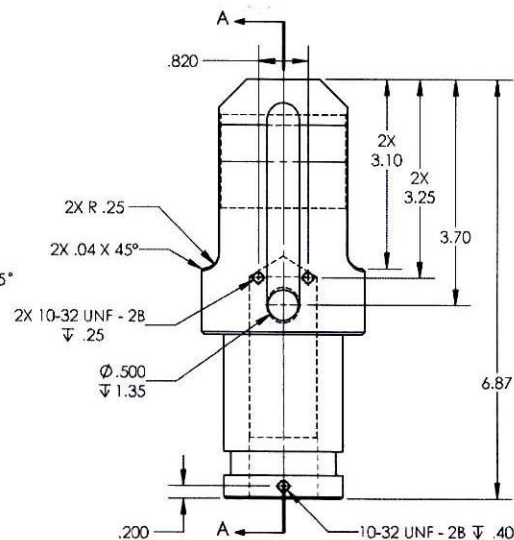
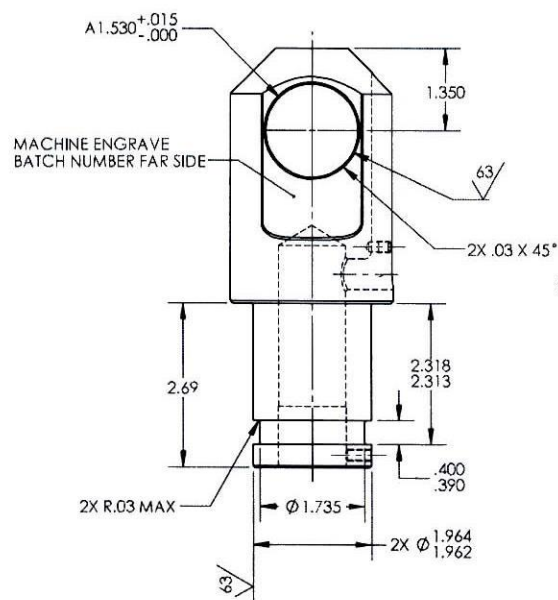
QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

Technical drawing of a circular part. The drawing shows a circle with a diameter dimension of $\varnothing 2.70$. A horizontal centerline is shown. A vertical dimension of 2.125 is shown across the top. A horizontal dimension of .366 is shown on the left side. A horizontal dimension of .030 is shown on the right side. A dimension of 2X R .25 is shown on the right side. A note at the bottom reads: "HIDDEN LINES REMOVED FOR CLARITY".

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172850



			
TITLE LOWER END			
DWG NO. SWA25A-110		REV 6	
MATERIAL SS 17-4 H1150/17-4 H1075		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS & 1/8	
HEAT TREAT FINISH		.XXX ± .005 ANGLES .5° .XXX ± .01 SURFACES ±.125	
SPEC		1. BREATHE ALL SHARP EDGES .015 ± .004 OR .015R	
DRAWN BY: CANAM		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED: CLOUGH		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR: ANDERSON		USED ON MODEL	
QA APPR: LINDSAY			
APPROVED: GILBERT			
SCALE 1:2	DATE 1/22/2002	SHEET 1 OF 1	

1.968

$$\begin{array}{r} 23.570 \\ \times 1.710 \\ \hline \end{array}$$

490

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					